

Date: Tuesday, 12/20/2005 8:09:45 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARPAW KIT (19"X16")	
Job Number	: 25289		Part Number	: K10007	
Estimate Number	: 10320		Drawing Number	: D2435 REV E1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/20/2005 S.O. No. : N/A		Drawing Revision	: E1	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/1/2006	
Previous Run	: N/A		Qty:	7 1/2	
Written By	: See comment below		Um:	10 Each	
Checked & Approved By	: See comment below				
Comment	: Est Rev:C 04.02.17 Blank size changed KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
	Comment: DOCUMENT CONTROL		
	Photocopy bluefile: K10007		
	D206-559		
	D500-572		
	D120-638		
	D058-678		
	and create labels per PPP K10005 CHG003		
	(Bag Bluefiles separately)		
			DH-06-01-02
2.0	MUHMWB10	UHMW 1" Black	
	Comment: Qty.: 4.5491 sf(s)/Unit Total : 45.4913 sf(s)		
	blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3		
	Material: Black UHMW 1"		
	(MUHMWB10)		
	Batch: M17227 - 10		
			15
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1		
	Note: (2) Bearpaw for (1) Kit		
	1-Inspect material for defects or damage prior to machining		
	2-Machine as per Folio and Dwg D2435 Identify as D2435		
	3-Deburr		
			SA 05.12.22 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/01/12	PKG	Rect 1 in stack D2435 B25289	CD	06/01/12	1	W 06/01/12	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	50 05-12-22 15
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	JL 05-12-28 15
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Pick Packing Kit	
7.0	D2182B050	Rubber Cushion
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	4 D2182B050 Rubber Cushion <u>B23172</u>	
8.0	D2274	Radius Block
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	8 D2274 Radius Block <u>B24482</u>	
	2 D2435(ref only) Bearpaw <u>B25289</u>	
9.0	D2438	Clamp
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	4 D2438 Clamp <u>B23818</u>	

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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:	Machine Or Operation:	Description :
10.0	D2529	Washer
		<b>Comment:</b> Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 8 D2529 Washer <u>A23177</u>
11.0	AN415A	Bolt
		<b>Comment:</b> Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 8 AN4-15A Bolt <u>M17566</u>
12.0	AN417A	Bolt
		<b>Comment:</b> Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 8 AN4-17A Bolt <u>M15432</u>
13.0	AN960JD416	Washer
		<b>Comment:</b> Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 16 AN960JD416 Washer <u>M6085</u>
14.0	MS21042L4	Nut
		<b>Comment:</b> Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 8 MS21042L4 Nut (or -4) <u>M17997</u>

W/O:		WORK ORDER CHANGES					
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Seq. #:	Machine Or Operation:	Description :
15.0	QS200M44S	Clamp
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 2 QS200M44S Clamp <u>B19504</u> 1 Paperwork package <u>1006/01/04 (7)</u></p>		
<p>Comment: INSPECT 100% KITS FOR COMPLETENESS <u>C206/01/12 7</u></p>		
17.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPPk10007 Location: <u>Pu 06/01/02 Rev E</u></p>		
18.0	DC	DOCUMENT CONTROL
<p>Comment: DOCUMENT CONTROL Inspection Level 21 <u>06/01/13</u></p>		
<p>Job Completion</p>		

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	25285
<b>Description:</b> Bearpaw	<b>Part Number:</b>	D2435
<b>Inspection Dwg:</b> D2435 <b>Rev:</b> E1		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	SA	Audited by:	SG	Prototype Approval:	N/A
Date:	05.12.22	Date:	05.12.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

**DART**

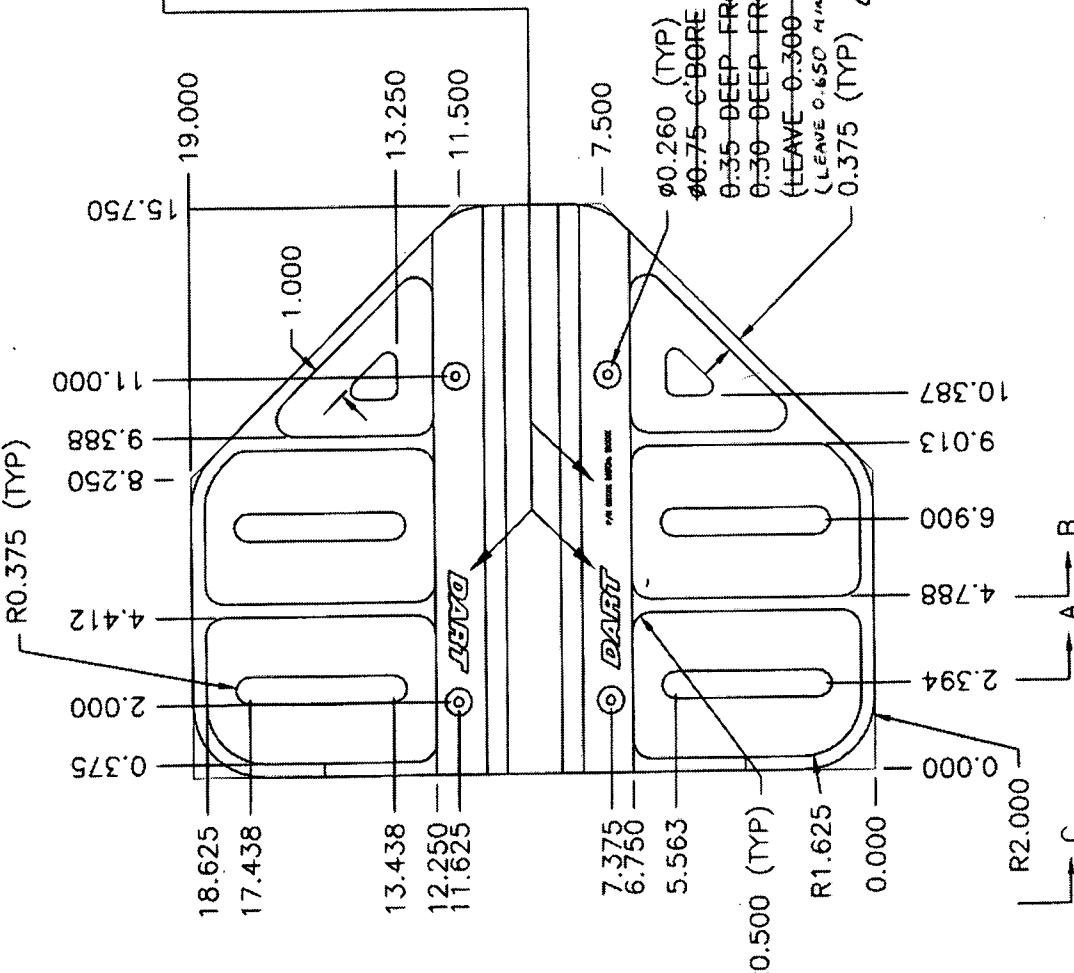
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2435	SHEET 1 OF 2
DATE		TITLE	SCALE
98.05.19		BEARPAW	1:5

**RELEASED**

98.06.17 KE

ENgrave logo to max  
depth of 0.012. Engrave  
part and batch numbers  
to max depth of 0.010.  
(typical location as  
illustrated)

A → B  
C →



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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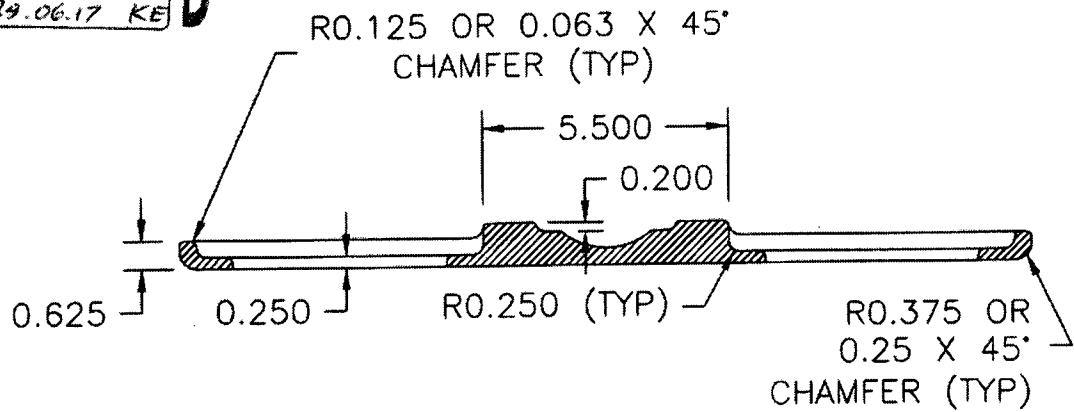
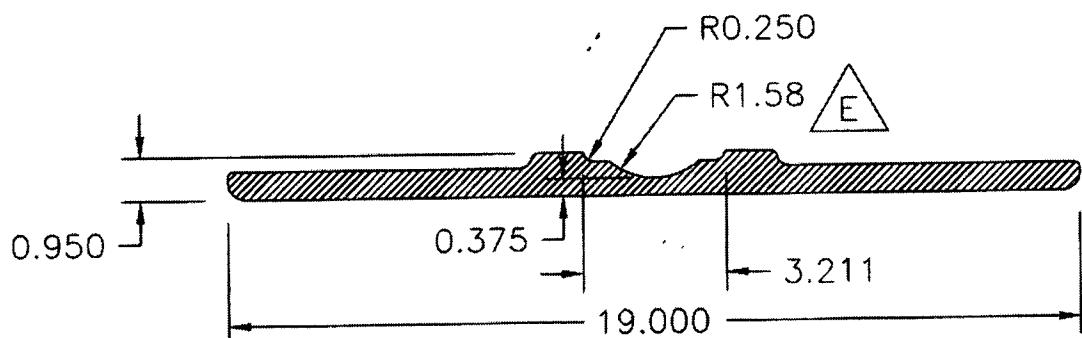
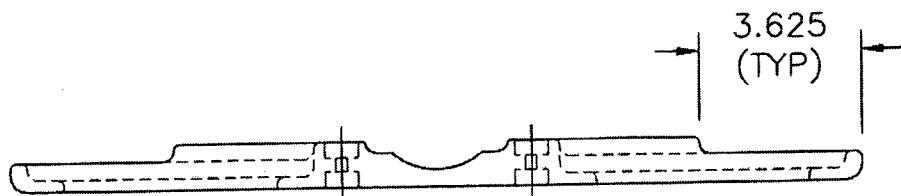
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2435
DATE		REV. E SHEET 2 OF 2 SCALE 1:4

**RELEASED**  
99.06.17 KESECTION A-ASECTION B-BSECTION C-C

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